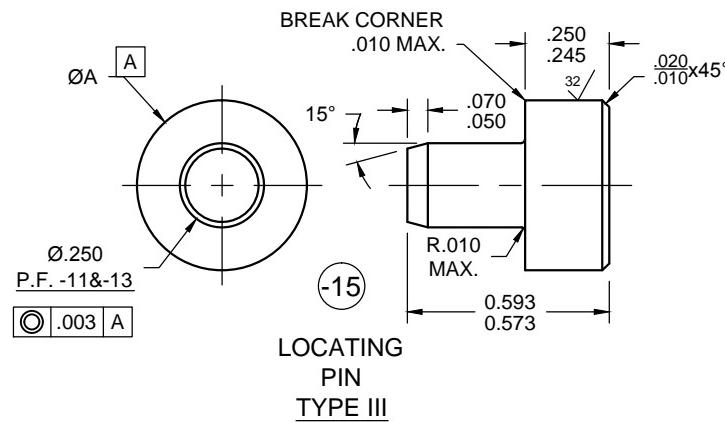


REV	DESCRIPTION	REVISIONS		
		DATE	INITIAL	APPROVED
1	ADDED NOTE TO -1 BODY TO INPECT BEFORE HEAT TREATING, ALSO CHANGED TOL., OF -1 ROLLER FIXTURE'S ØB, ØC, & ØE FROM +.002 -.000.	2/11/08	WP	DW
2	-15 CH'D LOCATING PIN TOLERANCE FROM Ø.2480 Ø.2475 TO Ø.250 P.F. -11 & -13. -11 & -13 CH'D FROM Ø.247 Ø.246 TO REAM Ø.290. REMOVED MS14102 & MS14104 CHAMFERED BEARINGS FROM LIST.	2/19/08	WP	GE
3	ADDED KST2128 & KST2162. -13 REMOVED 25° ANGLE FROM SECONDARY SEAT AND DELETED ØB DIMENSION. ADDED QTY TO -13 & -15 CHART.	4/22/08	WP	DW
4	-5 CH'D ROLLER RADIUS FROM .005 -.010, TO .015 -.020, -9 PIN RADIUS FROM .015 MAX., TO .015 MIN. CH'D -7 SLEEVE TO -7 GUIDE.	7/7/08	WP	DW
4A	CH'D T/N FROM KST2100.	11/19/09	RJC	
5	CORRECTED ERROR -3 WAS .165 NOW .172 FOR ROLLER CLEARANCE. ADDED REVISIONS TO ALL PAGES.	1/18/10	WP	DW
6	-15 DELETED LOCATING PIN TYPE I PER. R.W.	9/10/13	CFS	GE
7	-15 RBST2128 CH'D MATERIAL SIZE FROM Ø5/8 X 5/8 TO Ø3/4 X 5/8 & RBST2162 FROM Ø3/8 X 5/8 TO Ø1/2 X 5/8.	11/5/13	JAG	GE



NOTES:

- #### 1. BREAK ALL SHARP CORNERS (.015/.03)



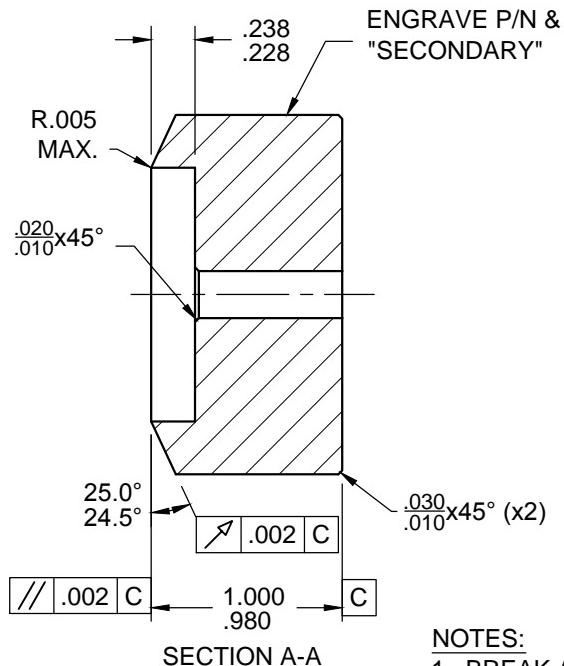
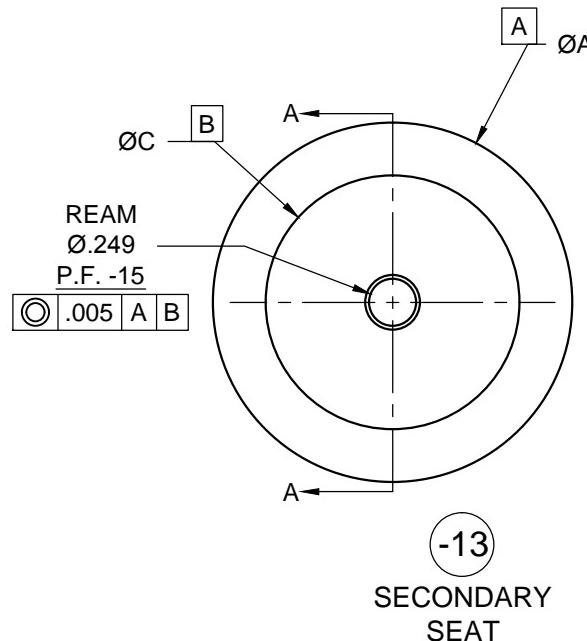
RED BARN MACHINE

TITLE RBST2100 SERIES TRI-ROLLER SWAGING
TOOL: LOCATING PIN

DWG NO.	TOOL# (see chart)-15			REV 7
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		DRAWN BY: PERRITT APPROVED <i>D. Neel</i>		
TOLERANCES ON: DECIMALS		HEAT TREAT FINISH SPEC		
XXX \pm .005	FRACTIONS \pm 1/32	BLACK OXIDE		
XX \pm .01	ANGLES \pm .5°	USED ON BEARING		
X \pm 1		SEE Pg. 1		
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR. .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING				
SCALE	NTS	DATE	1-23-08	SHEET 9 of 9

TOOL #	ØA +.000 -.002	PIN TYPE	QTY.	MATERIAL		
RBST2120	.310	III	2	1018	RND. BAR	Ø3/8 x 5/8
RBST2128	.622	III	1	1018	RND. BAR	Ø3/4 x 5/8
RBST2162	.372	III	1	1018	RND. BAR	Ø1/2 x 5/8

REVISIONS			
REV	DESCRIPTION	DATE	INITIAL APPROVED
1	ADDED NOTE TO -1 BODY TO INPECT BEFORE HEAT TREATING, ALSO CHANGED TOL., OF -1 ROLLER FIXTURE'S ØB, ØC, & ØE FROM +.002 -.000.	2/11/08	WP DW
2	-15 CH'D LOCATING PIN TOLERANCE FROM Ø.2480 Ø.2475 TO Ø.250 P.F. -11 & -13. -11 & -13 CH'D FROM Ø.247 Ø.246 TO REAM Ø.290. REMOVED MS14102 & MS14104 CHAMFERED BEARINGS FROM LIST.	2/19/08	WP GE
3	ADDED KST2128 & KST2162. -13 REMOVED 25° ANGLE FROM SECONDARY SEAT AND DELETED ØB DIMENSION. ADDED QTY TO -13 & -15 CHART.	4/22/08	WP DW
4	-5 CH'D ROLLER RADIUS FROM .005 -.010, TO .015 -.020, -9 PIN RADIUS FROM .015 MAX., TO .015 MIN. CH'D -7 SLEEVE TO -7 GUIDE.	7/7/08	WP DW
4A	CH'D T/N FROM KST2100.	11/19/09	RJC
5	CORRECTED ERROR -3 WAS .165 NOW .172 FOR ROLLER CLEARANCE. ADDED REVISIONS TO ALL PAGES.	1/18/10	WP DW



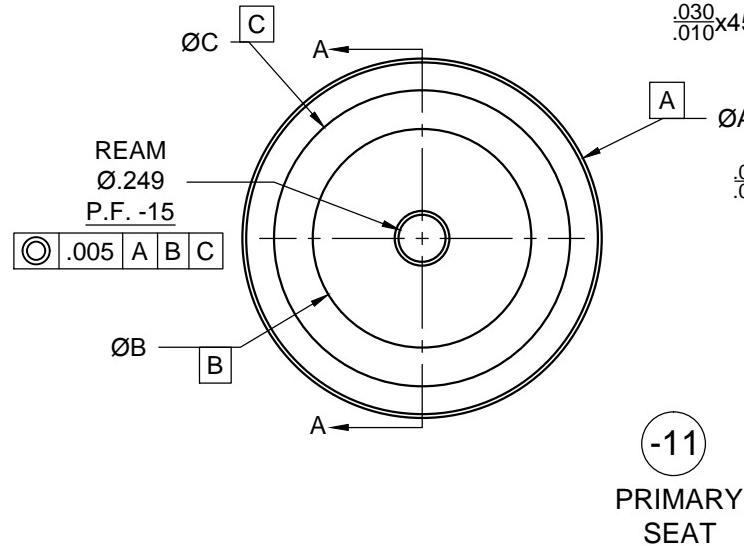
NOTES:

1. BREAK ALL SHARP CORNERS (.015/.03).

RED BARN MACHINE	
TITLE	RBST2100 SERIES TRI-ROLLER SWAGING TOOL; SECONDARY SEAT
DWG NO.	TOOL# (see chart)-13
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS XXX ± .005 XX ± .01 X ± .1	DRAWN BY: PERRITT APPROVED D. Weil HEAT TREAT FINISH SPEC BLACK OXIDE USED ON BEARING SEE Pg. 1
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 1-23-08
	SHEET 8 of 9

TOOL #	QTY.	ØA +.000 -.030	ØC +.000 -.005	MATERIAL
RBST2120	1	1.360	.968	4140 Q&T RND. BAR Ø1-3/8 x 1-1/8
RBST2128	0	0	0	NONE
RBST2162	0	0	0	NONE

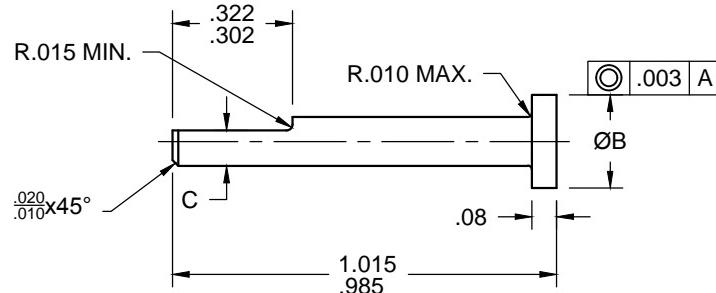
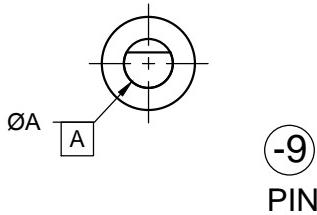
REVISIONS			
REV	DESCRIPTION	DATE	INITIAL APPROVED
1	ADDED NOTE TO -1 BODY TO INPECT BEFORE HEAT TREATING, ALSO CHANGED TOL., OF -1 ROLLER FIXTURE'S ØB, ØC, & ØE FROM +.002 -.000.	2/11/08	WP DW
2	-15 CH'D LOCATING PIN TOLERANCE FROM Ø.2480 Ø.2475 TO Ø.250 P.F. -11 & -13. -11 & -13 CH'D FROM Ø.247 Ø.246 TO REAM Ø.290. REMOVED MS14102 & MS14104 CHAMFERED BEARINGS FROM LIST.	2/19/08	WP GE
3	ADDED KST2128 & KST2162. -13 REMOVED 25° ANGLE FROM SECONDARY SEAT AND DELETED ØB DIMENSION. ADDED QTY TO -13 & -15 CHART.	4/22/08	WP DW
4	-5 CH'D ROLLER RADIUS FROM .005 -.010, TO .015 -.020, -9 PIN RADIUS FROM .015 MAX., TO .015 MIN. CH'D -7 SLEEVE TO -7 GUIDE.	7/7/08	WP DW
4A	CH'D T/N FROM KST2100.	11/19/09	RJC
5	CORRECTED ERROR -3 WAS .165 NOW .172 FOR ROLLER CLEARANCE. ADDED REVISIONS TO ALL PAGES.	1/18/10	WP DW



TOOL #	ØA +.000 -.030	ØB +.000 -.005	ØC +.002 -.002	D +.002 -.002	MATERIAL
RBST2100	1.360	.875	0	0	4140 Q&T RND. BAR Ø1-3/8 x 1-1/8
RBST2128	1.870	1.139	0	0	4140 Q&T RND. BAR Ø1-7/8 x 1-1/8
RBST2162	1.485	.881	1.183	.053	4140 Q&T RND. BAR Ø1-1/2 x 1-1/8

RED BARN MACHINE		
TITLE RBST2100 SERIES TRI-ROLLER SWAGING TOOL; PRIMARY SEAT		
DWG NO. TOOL# (see chart)-11 REV 7		
UNLESS OTHERWISE SPECIFIED DRAWN BY: PERRITT		
DIMENSIONS ARE IN INCHES		
TOLERANCES ON: DECIMALS XXX ± .005 FRACTIONS ± 1/32		
XX ± .01 ANGLES ± 5°		
X ± .1		
HEAT TREAT FINISH SPEC BLACK OXIDE		
USED ON BEARING SEE Pg. 1		
SCALE NTS	DATE 1-23-08	SHEET 7 of 9

REVISIONS			
REV	DESCRIPTION	DATE	INITIAL APPROVED
1	ADDED NOTE TO -1 BODY TO INPECT BEFORE HEAT TREATING, ALSO CHANGED TOL., OF -1 ROLLER FIXTURE'S ØB, ØC, & ØE FROM +.002 -.000.	2/11/08	WP DW
2	-15 CH'D LOCATING PIN TOLERANCE FROM Ø.2480 Ø.2475 TO Ø.250 P.F. -11 & -13. -11 & -13 CH'D FROM Ø.247 Ø.246 TO REAM Ø.290. REMOVED MS14102 & MS14104 CHAMFERED BEARINGS FROM LIST.	2/19/08	WP GE
3	ADDED KST2128 & KST2162. -13 REMOVED 25° ANGLE FROM SECONDARY SEAT AND DELETED ØB DIMENSION. ADDED QTY TO -13 & -15 CHART.	4/22/08	WP DW
4	-5 CH'D ROLLER RADIUS FROM .005 -.010, TO .015 -.020, -9 PIN RADIUS FROM .015 MAX., TO .015 MIN. CH'D -7 SLEEVE TO -7 GUIDE.	7/7/08	WP DW
4A	CH'D T/N FROM KST2100.	11/19/09	RJC
5	CORRECTED ERROR -3 WAS .165 NOW .172 FOR ROLLER CLEARANCE. ADDED REVISIONS TO ALL PAGES.	1/18/10	WP DW



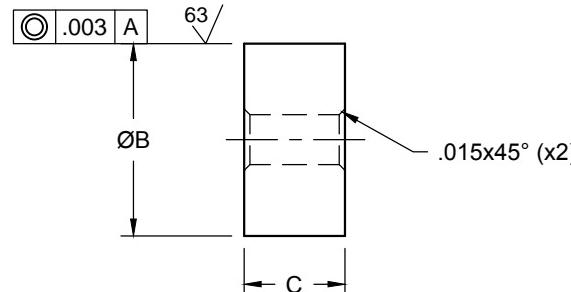
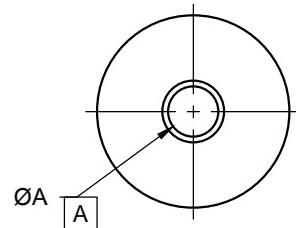
NOTES:

- BREAK ALL SHARP CORNERS (.015/.03).

RB RED BARN MACHINE	
TITLE	RBST2100 SERIES TRI-ROLLER SWAGING TOOL; PIN
DWG NO.	TOOL# (see chart)-9
REV	7
UNLESS OTHERWISE SPECIFIED	
DIMENSIONS ARE IN INCHES	
TOLERANCES ON:	
DECIMALS	
XXX	± .005
XX	± .01
X	± .1
FRACTIONS ± 1/32	
ANGLES ± 5°	
APPROVED <i>D. Weil</i>	
HEAT TREAT	
FINISH SPEC BLACK OXIDE	
USED ON BEARING	
SEE Pg. 1	
SCALE	NTS
DATE	1-23-08
SHEET	6 of 9

TOOL #	ØA +.000 -.001	ØB +.005 -.002	C +.000 -.020	MATERIAL
RBST2100	.129	.188	.104	MCMASTER-CARR PN: 98378A909
RBST2128	.129	.188	.104	MCMASTER-CARR PN: 98378A909
RBST2162	.129	.188	.104	MCMASTER-CARR PN: 98378A909

REVISIONS			
REV	DESCRIPTION	DATE	INITIAL APPROVED
1	ADDED NOTE TO -1 BODY TO INPECT BEFORE HEAT TREATING, ALSO CHANGED TOL., OF -1 ROLLER FIXTURE'S ØB, ØC, & ØE FROM +.002 -.000.	2/11/08	WP DW
2	-15 CH'D LOCATING PIN TOLERANCE FROM Ø.2480 Ø.2475 TO Ø.250 P.F. -11 & -13. -11 & -13 CH'D FROM Ø.247 Ø.246 TO REAM Ø.290. REMOVED MS14102 & MS14104 CHAMFERED BEARINGS FROM LIST.	2/19/08	WP GE
3	ADDED KST2128 & KST2162. -13 REMOVED 25° ANGLE FROM SECONDARY SEAT AND DELETED ØB DIMENSION. ADDED QTY TO -13 & -15 CHART.	4/22/08	WP DW
4	-5 CH'D ROLLER RADIUS FROM .005 -.010, TO .015 -.020, -9 PIN RADIUS FROM .015 MAX., TO .015 MIN. CH'D -7 SLEEVE TO -7 GUIDE.	7/7/08	WP DW
4A	CH'D T/N FROM KST2100.	11/19/09	RJC
5	CORRECTED ERROR -3 WAS .165 NOW .172 FOR ROLLER CLEARANCE. ADDED REVISIONS TO ALL PAGES.	1/18/10	WP DW



-7

GUIDE

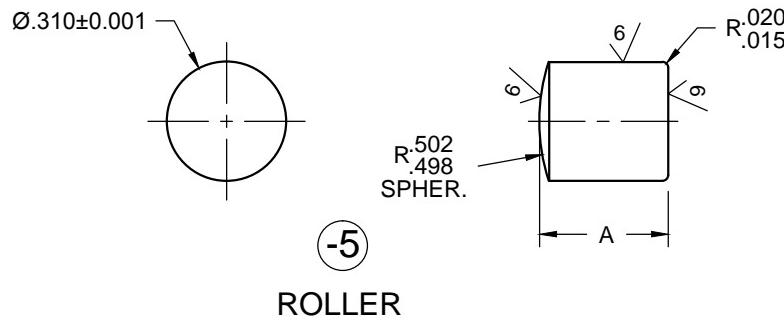
NOTES

- BREAK ALL SHARP CORNERS (.015/.03).

TOOL #	ØA +.001 -.001	ØB +.002 -.002	C +.000 -.010	MATERIAL
RBST2120	.131	.310	.390	BRONZE RND. BAR Ø5/16 x 1/2
RBST2128	.131	.622	.312	BRONZE RND. BAR Ø5/8 x 1/2
RBST2162	.131	.372	.312	BRONZE RND. BAR Ø3/8 x 1/2

RB RED BARN MACHINE	
TITLE RBST2100 SERIES TRI-ROLLER SWAGING TOOL; GUIDE	
DWG NO.	TOOL# (see chart)-7
REV 7	
UNLESS OTHERWISE SPECIFIED	
DIMENSIONS ARE IN INCHES	
TOLERANCES ON:	
DECIMALS .XXX ± .005 FRACTIONS ± 1/32	
XX ± .01 ANGLES ± 5°	
X ± .1	
APPROVED <i>D. Weil</i>	
HEAT TREAT	
FINISH SPEC	
USED ON BEARING	
SEE Pg. 1	
SCALE	NTS
DATE	1-23-08
SHEET	5 of 9

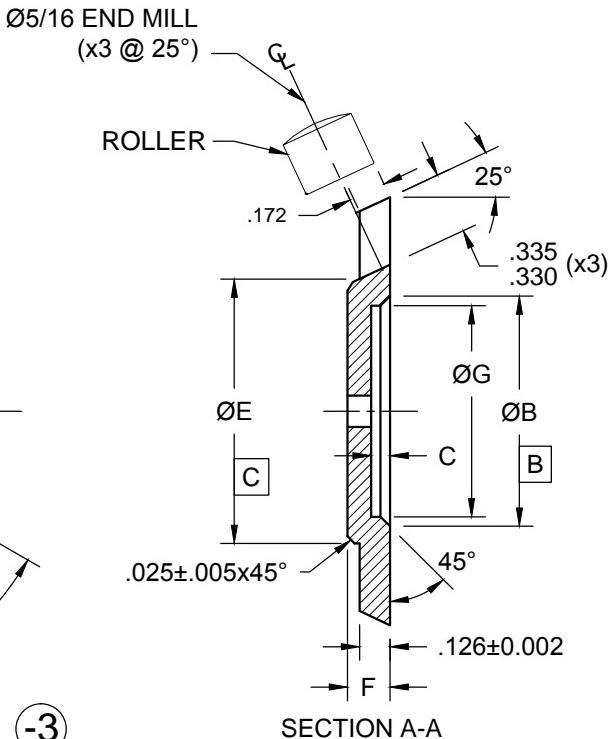
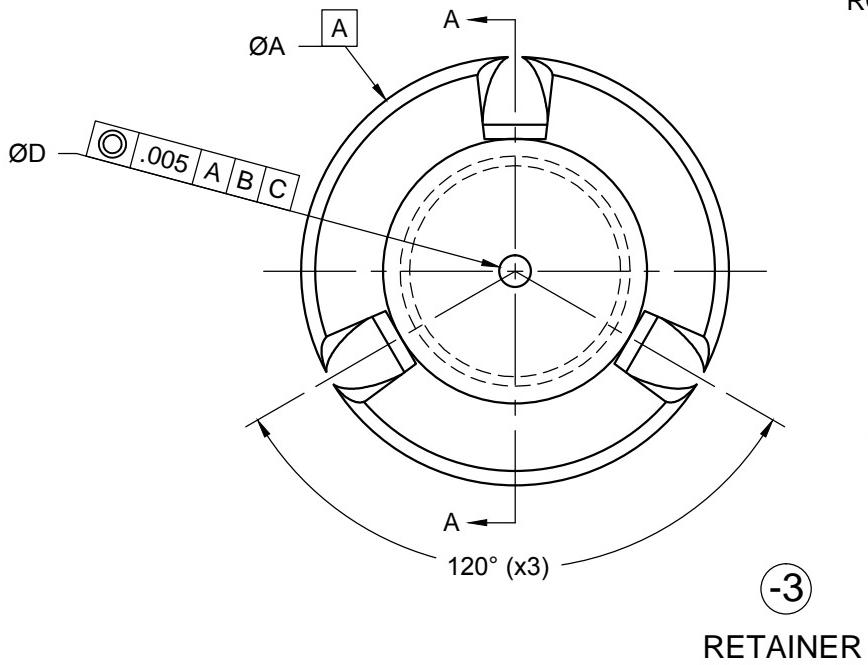
REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	ADDED NOTE TO -1 BODY TO INPECT BEFORE HEAT TREATING, ALSO CHANGED TOL., OF -1 ROLLER FIXTURE'S ØB, ØC, & ØE FROM +.002 -.000.	2/11/08	WP	DW
2	-15 CH'D LOCATING PIN TOLERANCE FROM Ø.2480 Ø.2475 TO Ø.250 P.F. -11 & -13. -11 & -13 CH'D FROM Ø.247 Ø.246 TO REAM Ø.290. REMOVED MS14102 & MS14104 CHAMFERED BEARINGS FROM LIST.	2/19/08	WP	GE
3	ADDED KST2128 & KST2162. -13 REMOVED 25° ANGLE FROM SECONDARY SEAT AND DELETED ØB DIMENSION. ADDED QTY TO -13 & -15 CHART.	4/22/08	WP	DW
4	-5 CH'D ROLLER RADIUS FROM .005 -.010, TO .015 -.020, -9 PIN RADIUS FROM .015 MAX., TO .015 MIN. CH'D -7 SLEEVE TO -7 GUIDE.	7/7/08	WP	DW
4A	CH'D T/N FROM KST2100.	11/19/09	RJC	
5	CORRECTED ERROR -3 WAS .165 NOW .172 FOR ROLLER CLEARANCE. ADDED REVISIONS TO ALL PAGES.	1/18/10	WP	DW



TOOL #	A +.001 -.001	MATERIAL		
RBST2120	.335	.310 MINUS GAUGE PIN	MSC#89031009	
RBST2128	.335	.310 MINUS GAUGE PIN	MSC#89031009	
RBST2162	.335	.310 MINUS GAUGE PIN	MSC#89031009	

RED BARN MACHINE	
TITLE RBST2100 SERIES TRI-ROLLER SWAGING TOOL; ROLLER (QTY. 3)	
DWG NO.	TOOL# (see chart)-5
UNLESS OTHERWISE SPECIFIED DRAWN BY: PERRITT	
DIMENSIONS ARE IN INCHES	
TOLERANCES ON: APPROVED D. Weil	
DECIMALS .XXX ± .005 FRACTIONS ± 1/32	
XX ± .01 .015 x 45° PR.015 R	
X ± .1 ANGLES ± 5°	
HEAT TREAT RC 55-60	
FINISH SPEC	
USED ON BEARING	
SEE Pg. 1	
SCALE	NTS
DATE	1-23-08
SHEET	4 of 9

REVISIONS			
REV	DESCRIPTION	DATE	INITIAL APPROVED
1	ADDED NOTE TO -1 BODY TO INPECT BEFORE HEAT TREATING, ALSO CHANGED TOL., OF -1 ROLLER FIXTURE'S ØB, ØC, & ØE FROM +.002 -.000.	2/11/08	WP DW
2	-15 CH'D LOCATING PIN TOLERANCE FROM Ø.2480 Ø.2475 TO Ø.250 P.F. -11 & -13. -11 & -13 CH'D FROM Ø.247 Ø.246 TO REAM Ø.290. REMOVED MS14102 & MS14104 CHAMFERED BEARINGS FROM LIST.	2/19/08	WP GE
3	ADDED KST2128 & KST2162. -13 REMOVED 25° ANGLE FROM SECONDARY SEAT AND DELETED ØB DIMENSION. ADDED QTY TO -13 & -15 CHART.	4/22/08	WP DW
4	-5 CH'D ROLLER RADIUS FROM .005 -.010, TO .015 -.020, -9 PIN RADIUS FROM .015 MAX., TO .015 MIN. CH'D -7 SLEEVE TO -7 GUIDE.	7/7/08	WP DW
4A	CH'D T/N FROM KST2100.	11/19/09	RJC
5	CORRECTED ERROR -3 WAS .165 NOW .172 FOR ROLLER CLEARANCE. ADDED REVISIONS TO ALL PAGES.	1/18/10	WP DW

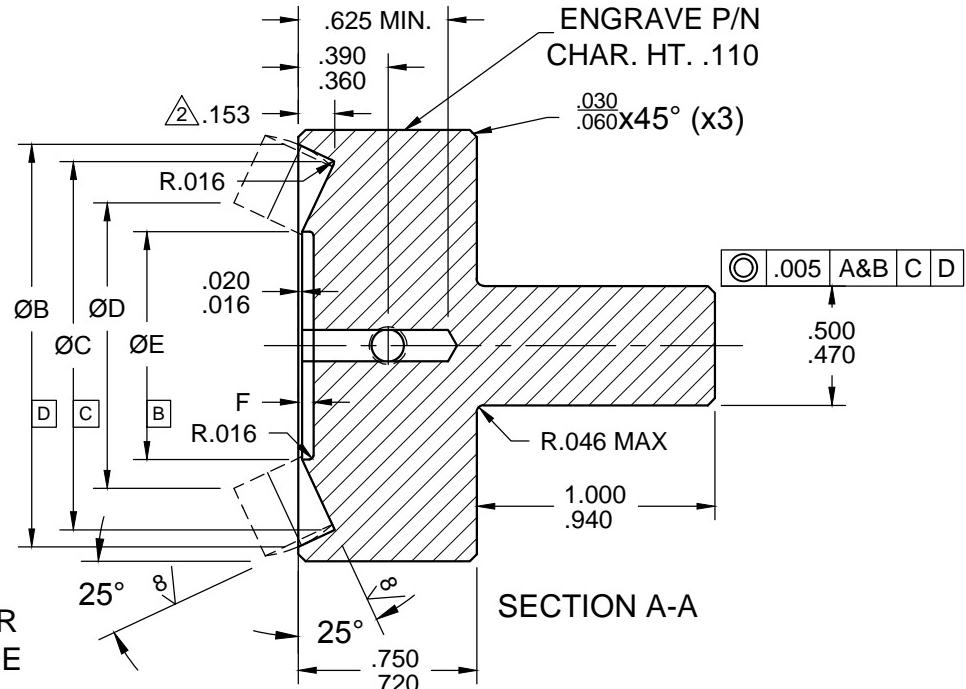
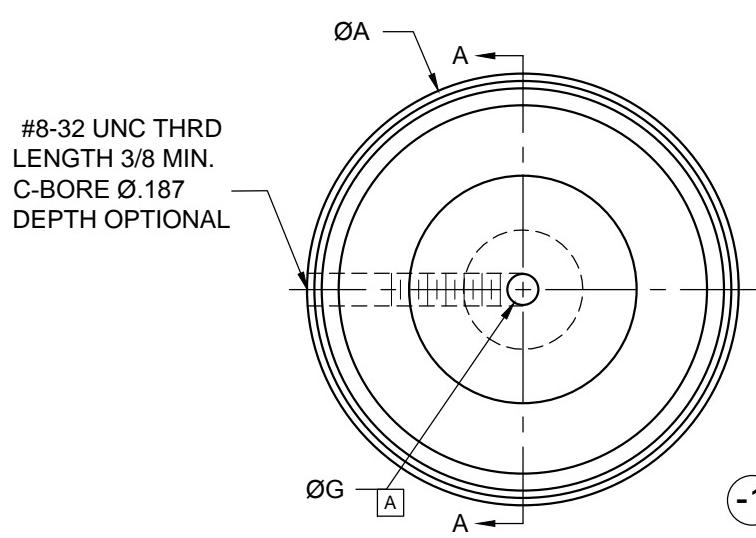


TOOL #	ØA +.002 -.002	ØB +.010 -.005	C +.020 -.000	ØD +.004 -.001	ØE +.000 -.015	F +.010 -.010	ØG +.005 -.005	P.D. REF.	MATERIAL
RBST2100	1.540	.700	.150	.136	.644	.210	.530	.968	BRONZE RND. BAR Ø1-5/8 x 3/8
RBST2128	1.857	1.077	.070	.136	0	0	.937	1.283	BRONZE RND. BAR Ø1-7/8 x 1/4
RBST2162	1.610	.775	.072	.136	0	0	.631	1.025	BRONZE RND. BAR Ø1-5/8 x 1/4

NOTES
1. BREAK ALL SHARP CORNERS (.015/.03).

RED BARN MACHINE		REV 7
TITLE RBST2100 SERIES TRI-ROLLER SWAGING TOOL; RETAINER		
DWG NO.	TOOL# (see chart)-3	REV 7
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		DRAWN BY: PERRITT
TOLERANCES ON: DECIMALS XXX ± .005 XX ± .01 X ± .1		APPROVED D. Weil
FRACTIONS ± 1/32 .015 x 45° PR.015 R ANGLES ± 5°		HEAT TREAT FINISH SPEC
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR.015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING		USED ON BEARING SEE Pg. 1
SCALE	NTS	DATE 1-23-08
		SHEET 3 of 9

REVISIONS			
REV	DESCRIPTION	DATE	INITIAL APPROVED
1	ADDED NOTE TO -1 BODY TO INPECT BEFORE HEAT TREATING, ALSO CHANGED TOL., OF -1 ROLLER FIXTURE'S ØB, ØC, & ØE FROM +.002 -.000.	2/11/08	WP DW
2	-15 CH'D LOCATING PIN TOLERANCE FROM Ø.2480 Ø.2475 TO Ø.250 P.F. -11 & -13. -11 & -13 CH'D FROM Ø.247 Ø.246 TO REAM Ø.290. REMOVED MS14102 & MS14104 CHAMFERED BEARINGS FROM LIST.	2/19/08	WP GE
3	ADDED KST2128 & KST2162. -13 REMOVED 25° ANGLE FROM SECONDARY SEAT AND DELETED ØB DIMENSION. ADDED QTY TO -13 & -15 CHART.	4/22/08	WP DW
4	-5 CH'D ROLLER RADIUS FROM .005 -.010, TO .015 -.020, -9 PIN RADIUS FROM .015 MAX., TO .015 MIN. CH'D -7 SLEEVE TO -7 GUIDE.	7/7/08	WP DW
4A	CH'D T/N FROM KST2100.	11/19/09	RJC
5	CORRECTED ERROR -3 WAS .165 NOW .172 FOR ROLLER CLEARANCE. ADDED REVISIONS TO ALL PAGES.	1/18/10	WP DW
6	-1 RBST2128 CH'D ØB WAS 1.802 IS 1.776, CH'D ØE WAS 1.042 IS 1.028.	9/10/13	CFS GE



TOOL #	ØA +.000 -.030	ØB +.005 -.000	ØC +.009 -.000	ØD P.D. REF. -.000	ØE +.008 -.000	F +.030 -.000	ØG +.000 -.001	MATERIAL	
								0-1 DRILL ROD Ø1-3/4 x 1-7/8	0-1 DRILL ROD Ø2 x 1-7/8
RBST2120	1.735	1.463	1.314	.968	.698	.130	.131		
RBST2128	2.000	1.776	1.629	1.283	1.028	0	.131	0-1 DRILL ROD Ø2 x 1-7/8	
RBST2162	1.875	1.521	1.375	1.031	.767	0	.131	0-1 DRILL ROD Ø2 x 1-7/8	

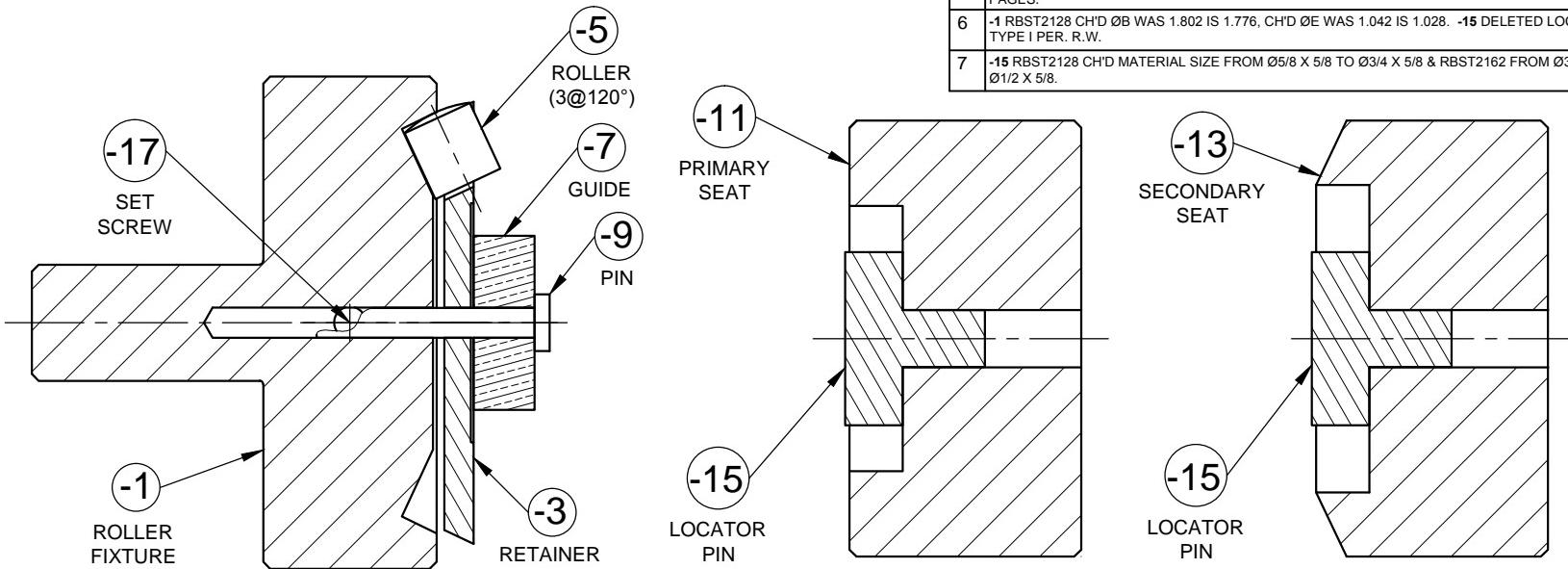
NOTES

1. BREAK ALL SHARP CORNERS (.015/.03).
DIMENSION TO BOTTOM OF R.016=.153;
DIMENSION TO SHARP CORNER=.158.
2. -1 BEARING RACE SURFACES MUST HAVE
SMOOTH APPEARANCE, FREE FROM
MACHINING MARKS AND GROOVES.
3. DO FIRST ARTICLE INSPECTION
BEFORE HEAT TREATING.

RED BARN MACHINE	
TITLE	RBST2100 SERIES TRI-ROLLER SWAGING TOOL; ROLLER FIXTURE
DWG NO.	TOOL# (see chart)-1
REV 7	
UNLESS OTHERWISE SPECIFIED	
DIMENSIONS ARE IN INCHES	
TOLERANCES ON:	
DECIMALS	FRACTIONS $\pm \frac{1}{32}$
XXX $\pm .005$	
XX $\pm .01$	ANGLES $\pm .5^\circ$
X $\pm .1$	
APPROVED <i>D. Weil</i>	
HEAT TREAT RC 55-60	
FINISH SPEC BLACK OXIDE	
USED ON BEARING	
SEE Pg. 1	
SCALE	NTS
DATE	1-23-08
SHEET	2 of 9

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL APPROVED
1	ADDED NOTE TO -1 BODY TO INPECT BEFORE HEAT TREATING, ALSO CHANGED TOL., OF -1 ROLLER FIXTURE'S ØB, ØC, & ØE FROM +.002 -.000.	2/11/08	WP DW
2	-15 CH'D LOCATING PIN TOLERANCE FROM Ø.2480 Ø.2475 TO Ø.250 P.F. -11 & -13. -11 & -13 CH'D FROM Ø.247 Ø.246 TO REAM Ø.290. REMOVED MS14102 & MS14104 CHAMFERED BEARINGS FROM LIST.	2/19/08	WP GE
3	ADDED KST2128 & KST2162. -13 REMOVED 25° ANGLE FROM SECONDARY SEAT AND DELETED ØB DIMENSION. ADDED QTY TO -13 & -15 CHART.	4/22/08	WP DW
4	-5 CH'D ROLLER RADIUS FROM .005 -.010, TO .015 -.020, -9 PIN RADIUS FROM .015 MAX., TO .015 MIN. CH'D -7 SLEEVE TO -7 GUIDE.	7/7/08	WP DW
4A	CH'D T/N FROM KST2100.	11/19/09	RJC
5	CORRECTED ERROR -3 WAS .165 NOW .172 FOR ROLLER CLEARANCE. ADDED REVISIONS TO ALL PAGES.	1/18/10	WP DW
6	-1 RBST2128 CH'D ØB WAS 1.802 IS 1.776, CH'D ØE WAS 1.042 IS 1.028. -15 DELETED LOCATING PIN TYPE I PER. R.W.	9/10/13	CFS GE
7	-15 RBST2128 CH'D MATERIAL SIZE FROM Ø5/8 X 5/8 TO Ø3/4 X 5/8 & RBST2162 FROM Ø3/8 X 5/8 TO Ø1/2 X 5/8.	11/5/13	JAG GE



NOTES

- 5 ROLLERS MUST TURN FREELY IN -3 RETAINER POCKETS.
- 5 ROLLERS & -3 RETAINER MUST TURN FREELY WHEN TOOL IS COMPLETELY ASSEMBLED.
- FLAT END OF ROLLERS MUST FACE TOWARDS THE CENTER OF THE TOOL WHEN ASSEMBLED.

ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	B/O INFORMATION OR SPECIFICATIONS	Pg.	TITLE	
							DWG NO.	TOOL# (see chart above)
		-1	1	ROLLER FIXTURE	SEE CHART	2		RED BARN MACHINE
		-3	1	RETAINER	SEE CHART	3		RBST2100 SERIES TRI-ROLLER SWAGING TOOL; ASSEMBLY
		-5	3	ROLLER	SEE CHART	4		TOOL# (see chart above)
		-7	1	GUIDE	SEE CHART	5		REV 7
		-9	1	PIN	SEE CHART	6	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS XXX ± .005 XX ± .01 X ± .1	DRAWN BY: PERRITT
		-11	1	PRIMARY SEAT	SEE CHART	7	FRACTIONS ± 1/32 ANGLES ± 5°	APPROVED D. Weil
		-13	0 or 1	SECONDARY SEAT	SEE CHART	8	HEAT TREAT LISTED PER ITEM FINISH SPEC LISTED PER ITEM USED ON BEARING	
		-15	1 or 2	LOCATING PIN	SEE CHART	9	UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR.015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING SEE ABOVE	
B/O	-17	1		SOCKET HEAD SET SCREW	#8-32 x 1/4	N/S	SCALE NTS DATE 1-4-08	SHEET 1 of 9

ASSY QTY	ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MAT.	B/O INFORMATION OR SPECIFICATIONS
			-1	1	RND	6061	Ø8-1/4 x 3-7/8
ASSY #							

NOT APPROVED FOR PRODUCTION

APPROVED FOR PRODUCTION

DESCRIPTION	MAT.	B/O INFORMATION OR SPECIFICATIONS	Pg.
	6061	Ø8-1/4 x 3-7/8	2

TITLE --

DWG NO. . . .

RE

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES

TOLERANCES ON:

DECIMALS .XXX ± .005 **FRACTIONS** ± 1/32
.XX ± .01 **ANGLES** ± 5°
X ± .1

DRAWN BY: PERRITT
APPROVED

HEAT
TEMP
FINISH
SPEC

UNLESS OTHERWISE SPECIFIED

USED ON MODEL

REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPR
—	—	—	—	—

RB		RED BARN MACHINE		
TITLE				
DWG NO. RE				
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON:			DRAWN BY: PERRITT	
DECIMALS .XXX ± .005 FRACTIONS ± 1/32 .XX ± .01 ANGLES ± .5° X ± .1			APPROVED HEAT TREAT FINISH SPEC	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES 0.15 x 45° PR. 0.15 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING			USED ON MODEL	
SCALE	NTS	DATE	8-15-07	SHEET
1 of 1				

NOT APPROVED FOR PRODUCTION

REVISIONS			
REV	DESCRIPTION	DATE	APPROVED

PART #	QTY	DESCRIPTION
-1	1	--

DRAWN BY: PERRITT	RB	RED BARN MACHINE
CHECKED		
HEAT		
TREAT		
FINISH SPEC		
USED ON MODEL	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
?	TOLERANCES ON: DECIMALS .XXX ± .005 FRACTIONS ± 1/32 .XX ± .01 ANGLES ± 5° .X ± .1	
	UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES 0.015 x 45° PR. 0.015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
	DWG NO.	TITLE
	SCALE NTS	DATE 1-28-06
		SHEET 1 of 1

4A	CONT'D FROM RS12100.
5	CORRECTED ERROR -3 WAS .165 NOW .172 FOR ROLLER CLEARANCE. ADDED REVISIONS TO ALL PAGES.
6	-1 RBST2128 CH'D ØB WAS 1.802 IS 1.776, CH'D ØE WAS 1.042 IS 1.028.

TEST SUBJECT APPROVED FOR PRODUCTION

PART #	QTY	DESCRIPTION
-1	1	0-1 DRILL ROD Ø2-1/8 x 1-7/8
-3	1	BRASS RND Ø2 x 5/16
-5	3	0-1 DRILL ROD Ø3/8 x 1/2

DRAWN BY:	PERRITT
APPROVED	RB
HEAT	

NOTES

1. ENGRAVE P/N; CHARACTER H
2. ENGRAVE 'PRIMARY'
3. ENGRAVE 'SECONDARY'

RED BARN MAC